

Work Order ID 106520

106520

Page 1

September-05-13 10:43:41 AM

Item ID: D4003-049

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tank Vent Line Assembly

Start Date: 9/05/13 Start Qty: 5.00

5

Cust Item ID:

Required Date: 9/12/13 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4003	A								
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1- Form tube as per dwg D4003 2- Insert sleeve before flaring								
120	QCS- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									

5 0 13-09-09

27 2.8 13.9.9

3 5 13-9-10

Work Order ID 106520

106520

Page 2

September-05-13 10:43:41 AM

Item ID: D4003-049 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tank Vent Line Assembly
 Start Date: 9/05/13 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 9/12/13 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				5			8/13/09/10
150 *150* Small Fab Small Fab	Memo Install nut as per dwg	0.00 0.00				5	4		FF 13-09-10
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				5			27 13-09-10

3

Work Order ID 106520

106520

Page 3

September-05-13 10:43:41 AM

Item ID: D4003-049 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tank Vent Line Assembly
 Start Date: 9/05/13 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 9/12/13 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST243</u>	0.00							
170									
Packaging	Memo	0.00				5x	128	13-09-10	
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

13-09-11

33

Picklist Print

September-05-13 10:43:40 AM

Page 1

Work Order ID: 106520
Parent Item: D4003-049
Parent Item Name: Tank Vent Line Assembly

Start Date: 9/05/13

Required Date: 9/12/13

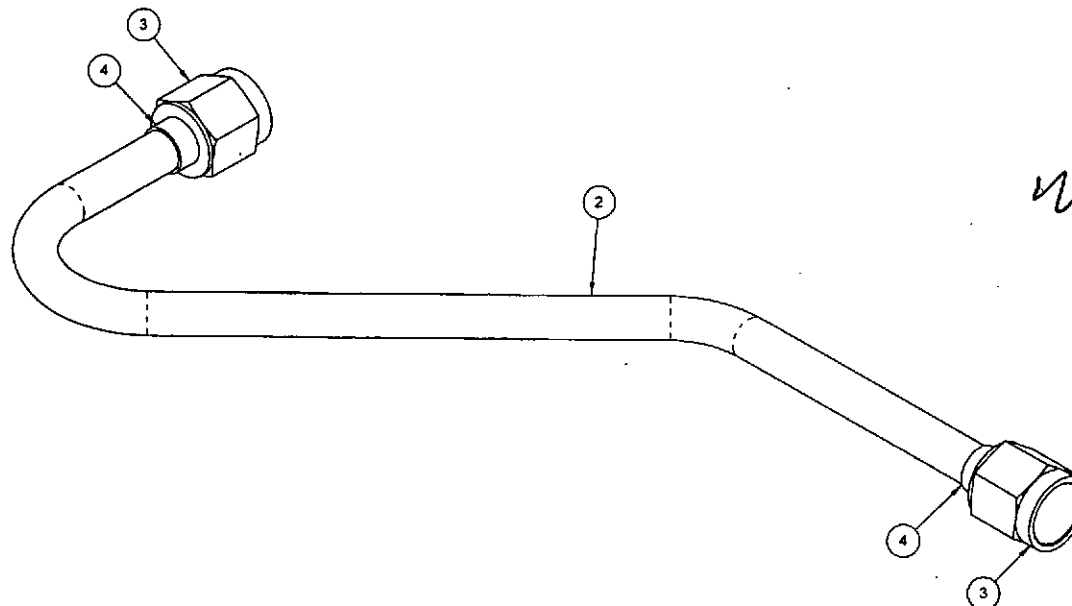
Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev A 10.01.05 new Issue Prelim EC verified by: DD IPP Rev B 10.05.13 ecn 10-562
EC verified by:DD IPP REV:C 13.04.17 NOW MADE IN HOUSE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN818-8D Nut		Purchased	No				Each	30.0000		5		FF 13-09-09	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST348		25							
				125445		10							
				m126474		15							
				ST349		5							
				122265		5							
M6061T6T0.500W.035 6061-T6 RD Tube .500 x.035W		Purchased	No				f	115.5300		7.5		FF 13-09-09	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT014		115.53							
				121848		89.18							
				4692		26.35							
MS20819-8D Sleeve		Purchased	No				Each	50.0000		5		FF 13-09-09	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST312		50							
				119531		5							
				123900		15							
				m126275		30							

ITEM NO.	QTY. -047	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4003-047	FUEL PUMP INLET PIPE	JCA-M47-2-16
2	1	D4003-7	FUEL INLET PIPE	
3	2	AN818-6D	NUT	
4	2	MS20818-6D	SLEEVE	



D4003-047 FUEL PUMP INLET PIPE

RELEASED
2010-05-05
NAP

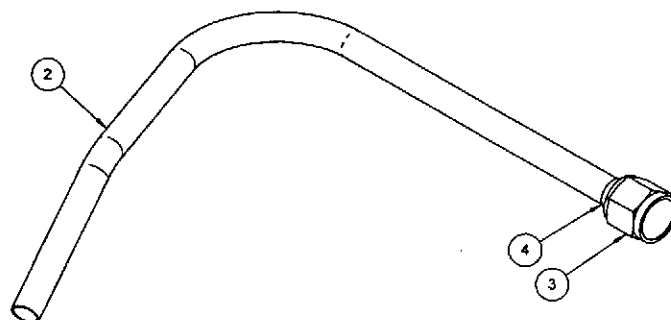
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-047" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs

A	NEW ISSUE		10 02 05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4003	REV. A
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ITEM NO.	QTY. -049	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4003-049	TANK VENT LINE ASSEMBLY	JCA-847-2-17
2	1	D4003-9	VENT LINE	
3	1	AN818-8D	NUT	
4	1	MS20819-8D	SLEEVE	



D4003-049 TANK VENT LINE ASSEMBLY

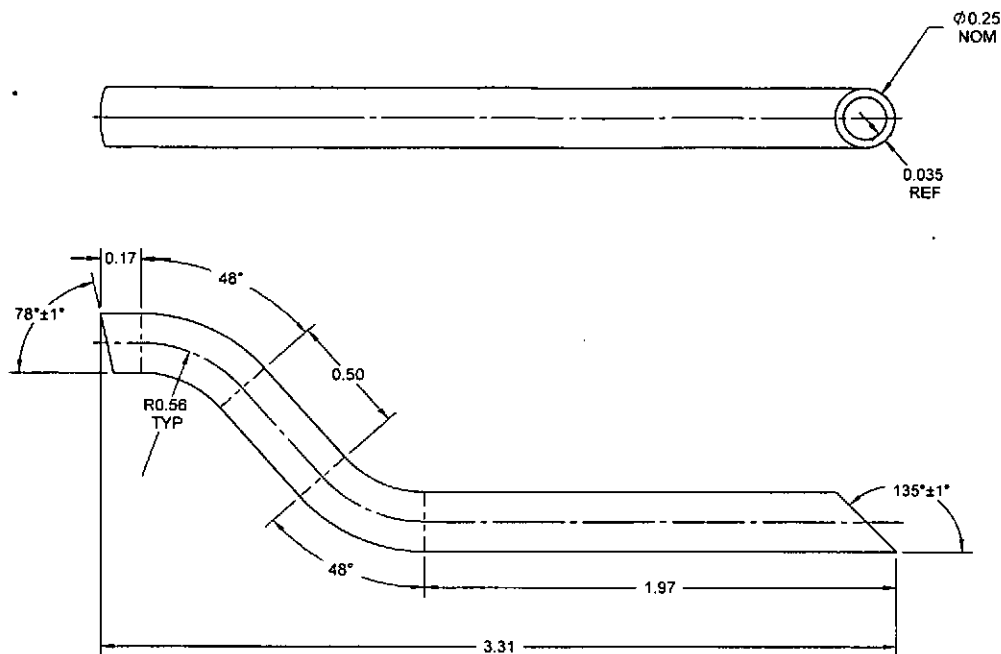
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2010-05-05
AMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-049" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-1	REF JCA-M47-1-06



D4003-1 INTERNAL DRAIN LINE, AFT

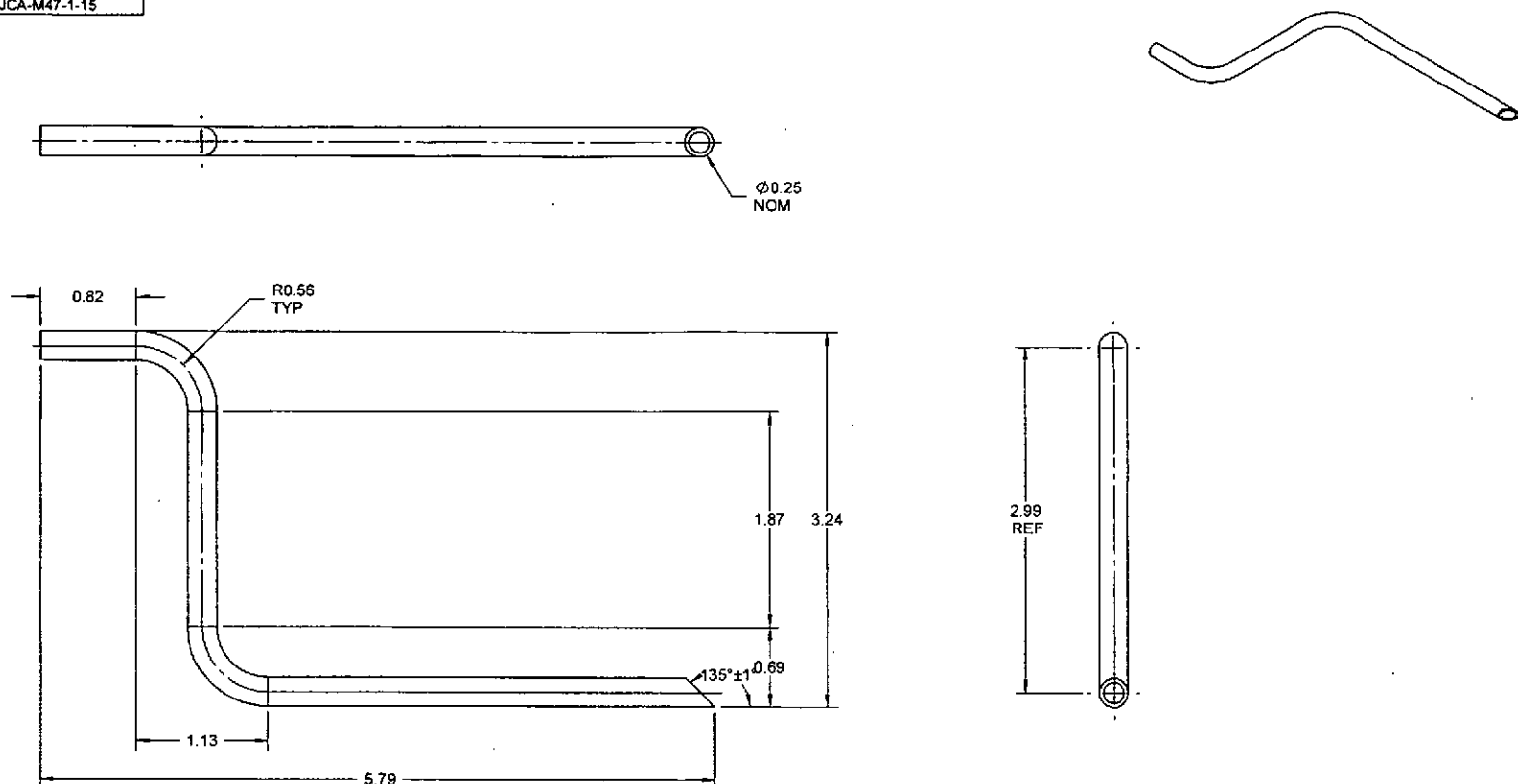
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NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, $\varnothing 0.25 \times 0.035$ WALL THICKNESS PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF DART SPEC 6061T6T0.250W.035
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-3	REF JCA-M47-1-15



D4003-3 INTERNAL DRAIN LINE, FWD

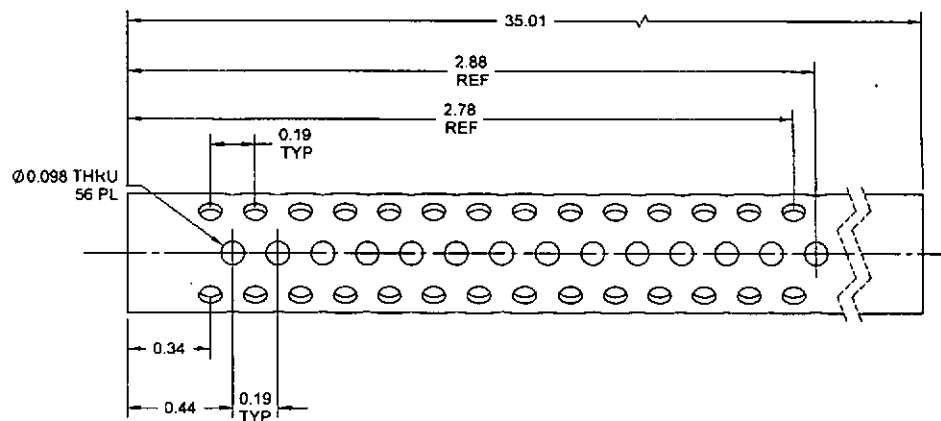
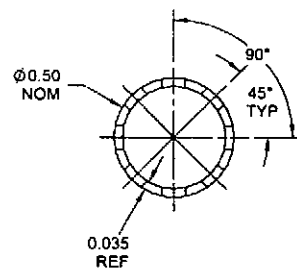
RELEASED
2010-05-05
MP

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, $\phi 0.25 \times 0.035$ WALL THICKNESS
PER WW-T-700/B OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC 6061T6T0.250W.035
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-5	REF JCA-M47-1-10



D4003-5 FUEL PICK UP LINE

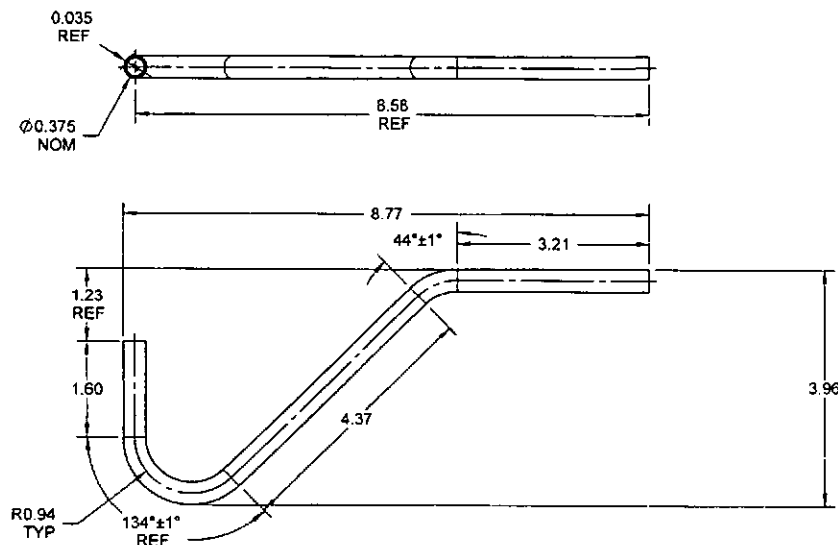
RELEASED
2010-05-05
MPD

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.500 X 0.035 WALL THICKNESS
REF WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DAT SPEC M6061T6T0.500W.035
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

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DATE	10.02.05		

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-7	REF JCA-M47-2-16



D4003-7 FUEL INLET PIPE

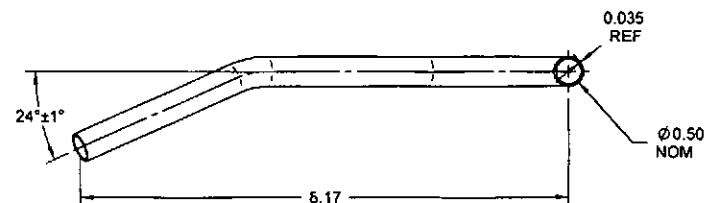
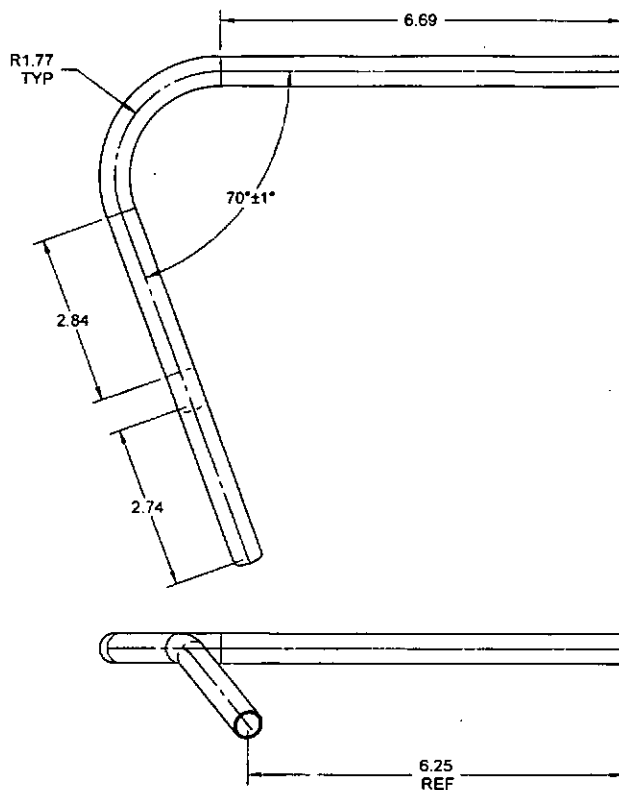
RELEASED
2010-05-05
AM

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, $\phi 0.375$ X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T6T0.375W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-9	REF JCA-M47-2-17



D4003-9 VENT LINE

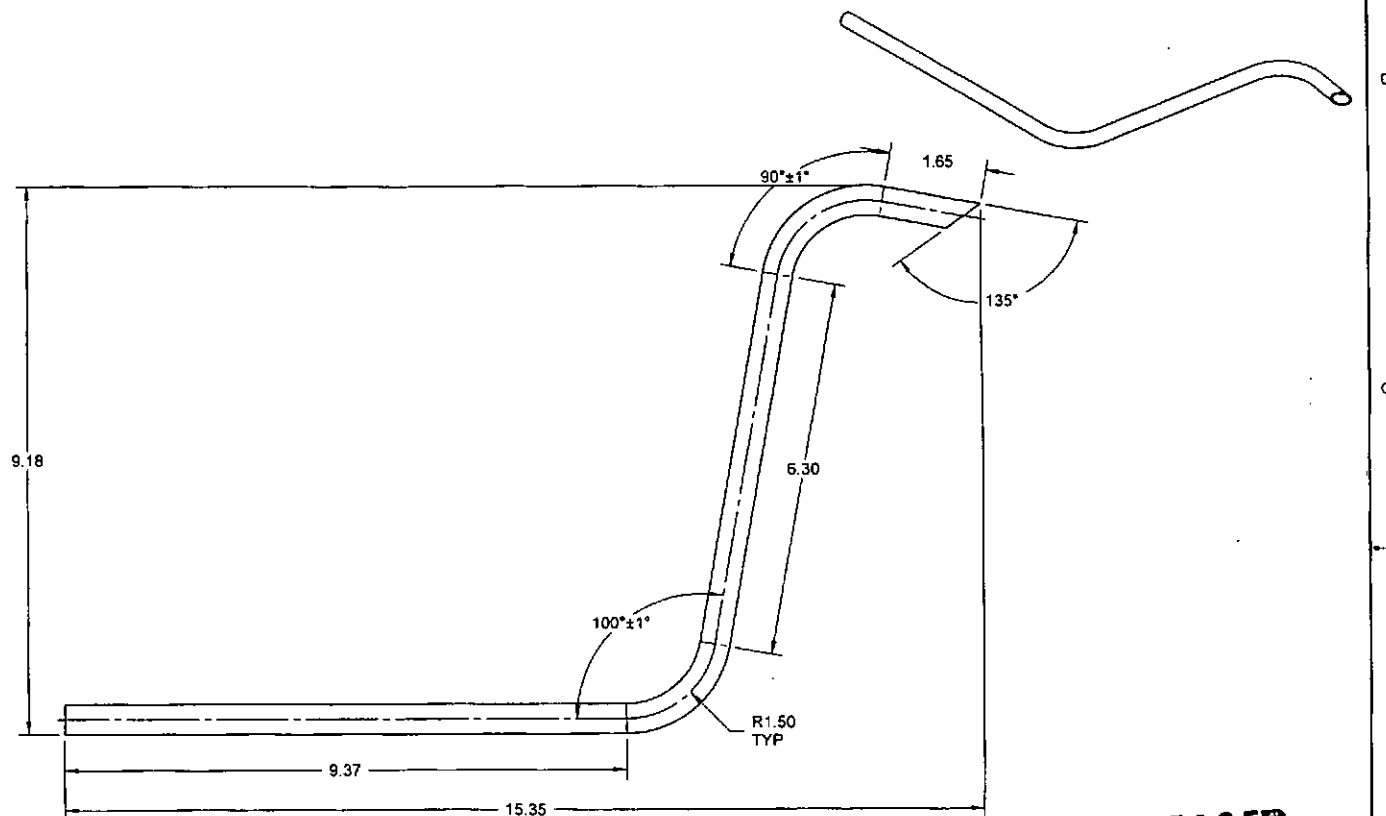
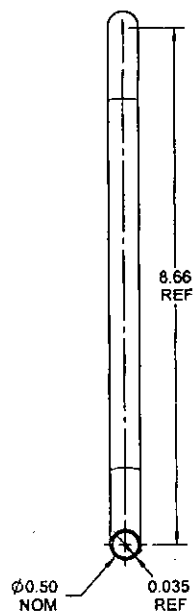
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2010-05-05
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NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Ø0.500 X 0.035 WALL THICKNESS
PER WW-T-700/S OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T60.500W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-11	JCA-M47-2-21









D4003-11 VENT PIPE - TANK

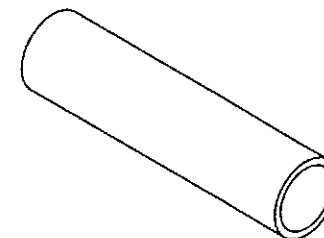
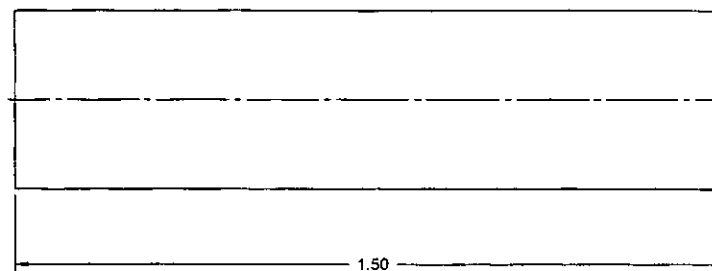
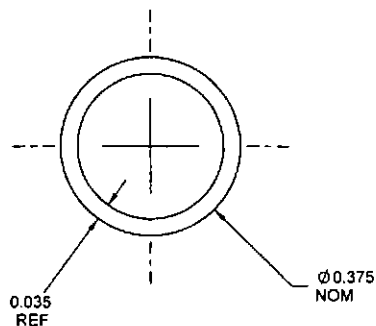
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NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, $\phi 0.500 \times 0.035$ WALL THICKNESS
PER WW-T-700/8 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T60.500W.035
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-11" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D4003	SHEET 6 OF 9
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4003-13	REF JCA-M47-2-22



D4003-13 FORWARD FUEL GUTTER LINE

RELEASED
2010-05-05
WP

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING. Ø0.375 X 0.035 WALL THICKNESS
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T6T0.375V.035
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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